

# Work Order ID 95611

**\*95611\***

Page 1

January-15-13 2:41:17 PM

Item ID: D3188-2M

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: SPACEPOD BODY RH

Start Date: 1/15/13 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/15/13 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set-Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3188

Rev F

100

0.00

**\*100\***

Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O:

18720

Description: D3188-2MBODY

SHIP: QTY (8) D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

CZ 13/01/15 ①

110

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*110\***

Packaging

Packaging

Memo

0.00

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

13/01/15 ①



# Work Order ID 95611

\*95611\*

Page 2

January-15-13 2:41:17 PM

Item ID: D3188-2M

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: SPACEPOD BODY RH

Start Date: 1/15/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 2/15/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
*120*									
QC	Memo	0.00							
Quality Control	Check for void spot and pins.								
130	Identify as per dwg & Stock Location: <u>w/o 95172</u>	0.00							
*130*									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

DAS  
16  
9-89

13/08/23

13-08-29

13/9/38

13-09-7

101  
42  
10

# Picklist Print

January-15-13 2:41:17 PM

Page 1

Work Order ID: 95611

Parent Item: D3188-2M

Parent Item Name: SPACEPOD BODY RH

Start Date: 1/15/13

Required Date: 2/15/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC  
 IPP rev B rev D dwg 07.03.07 ec  
 IPP rev C rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2213 Insert		Manufactured	No			100	Each	130.0000	8	8		1/13/13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		130							
				30809		130							
D3188-2P Spacepod Body		Purchased	No			110	Each	0.0000	1	1		1/43/13	



**GENERAL NOTES:**

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYLCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.  
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A  
D3188-2 = N/A  
D3188-3 = N/A  
D3188-5 = N/A  
D3188-6 = N/A  
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

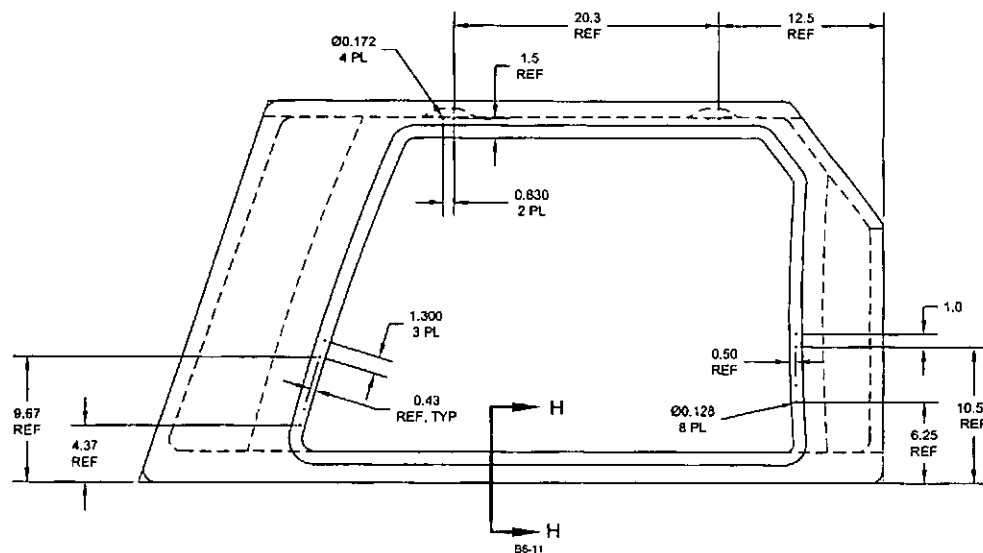
**RELEASED**  
2009-10-20  
*MD*

*W/B  
9564*

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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**D3188-1 SPACEPOD BODY**  
MAKE FROM D3188-1M

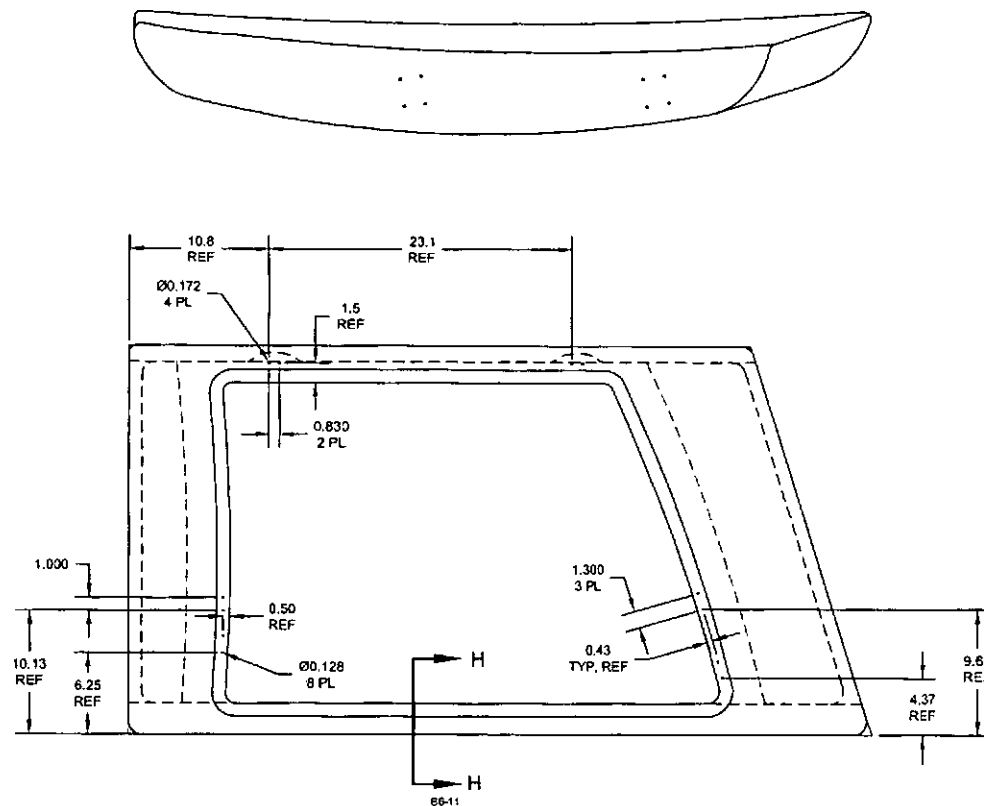
**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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NAD

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**D3188-2 SPACEPOD BODY**  
MAKE FROM D3188-2M

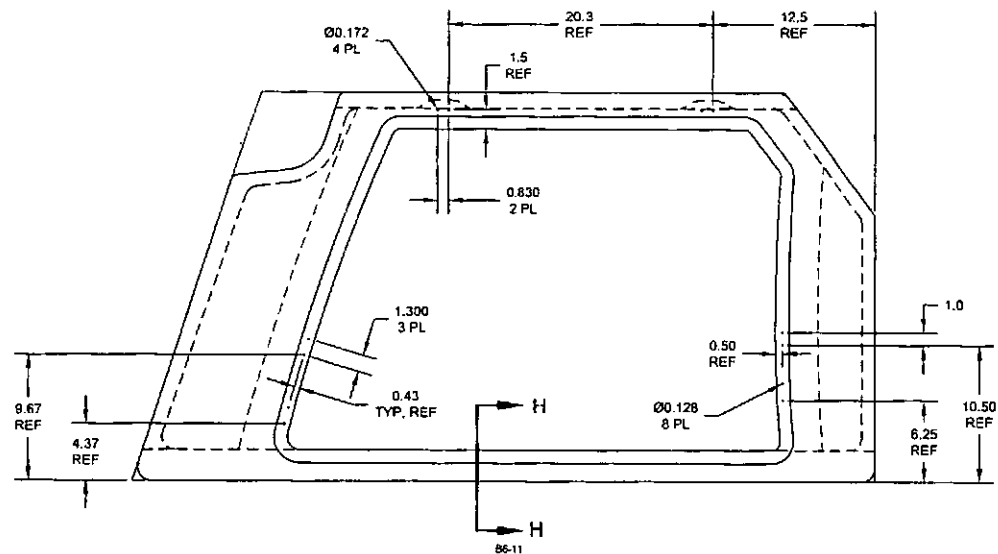
**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 3 OF 11
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**D3188-3 SPACEPOD BODY**  
MAKE FROM D3188-3M

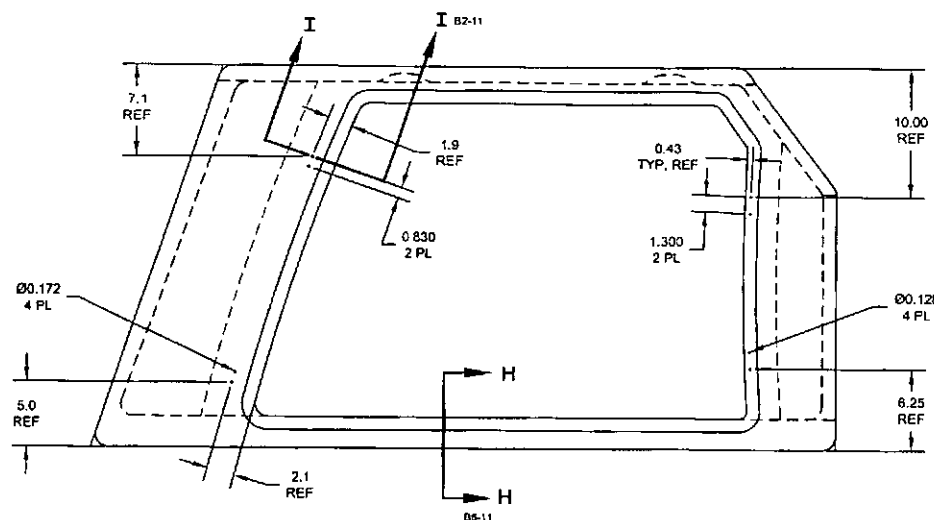
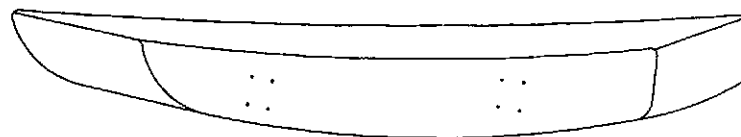
**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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**D3188-5 SPACEPOD BODY**  
MAKE FROM D3188-1M

**NOTES:**

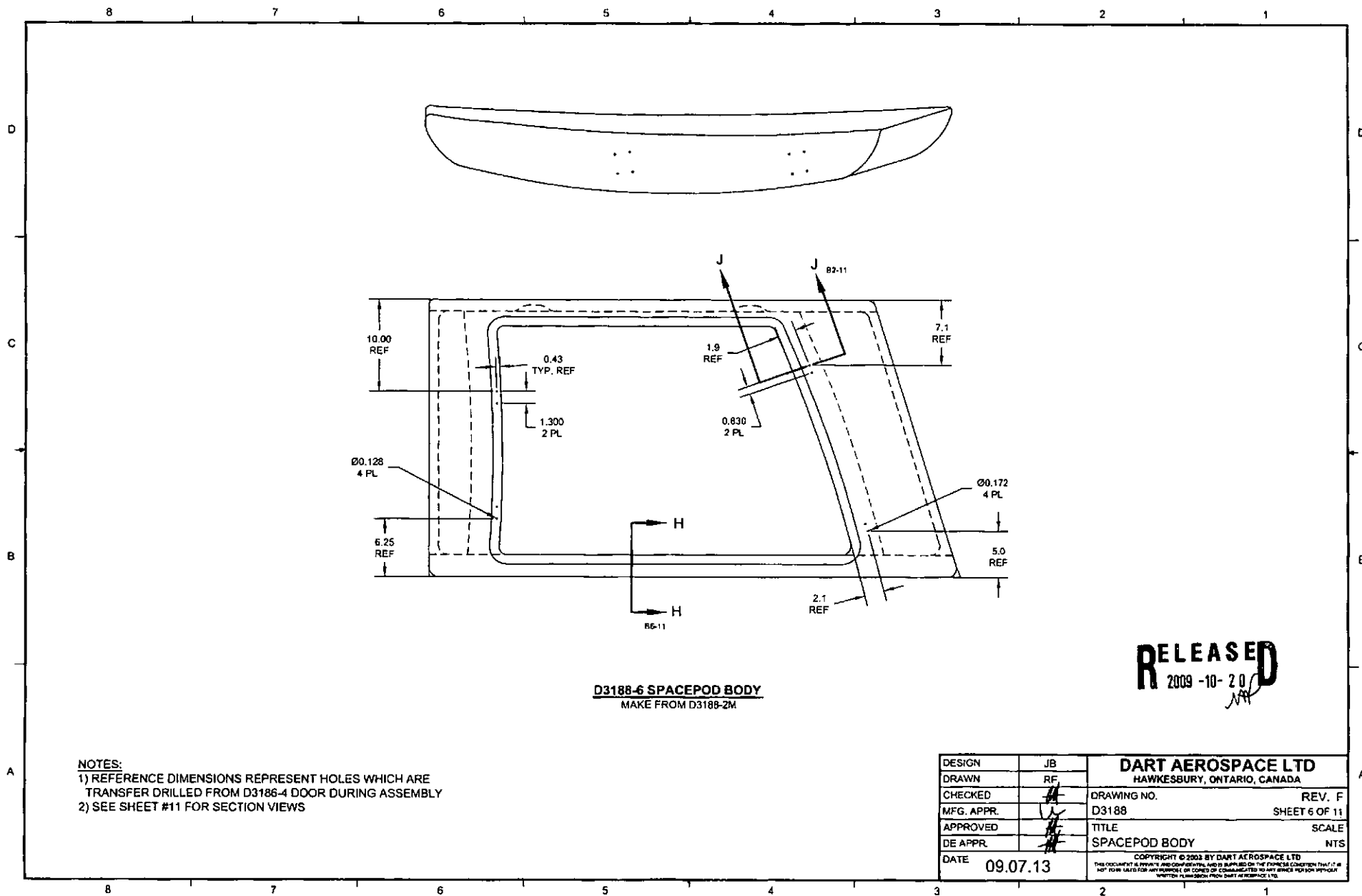
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

**RELEASED**  
2009-10-20

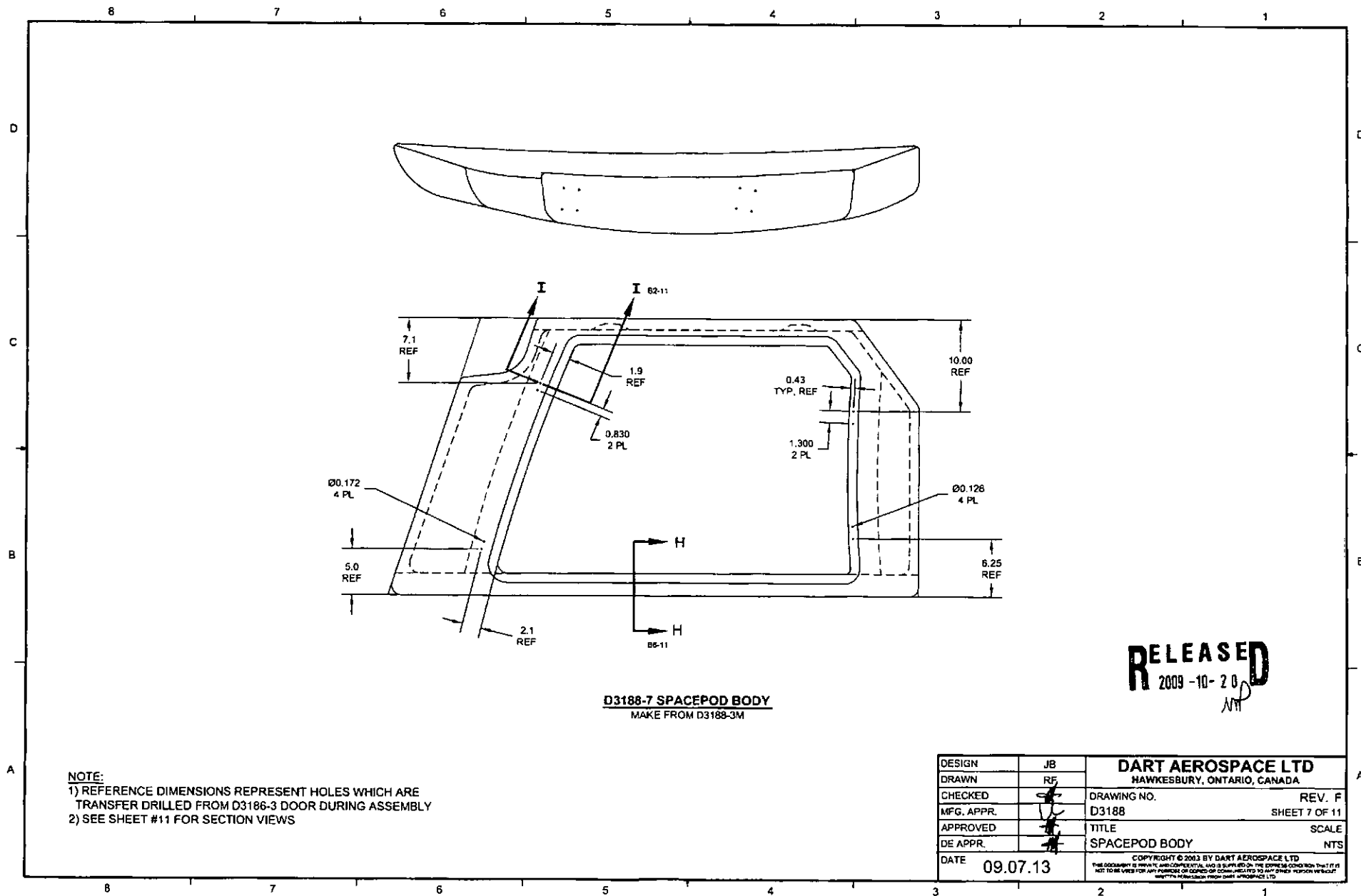
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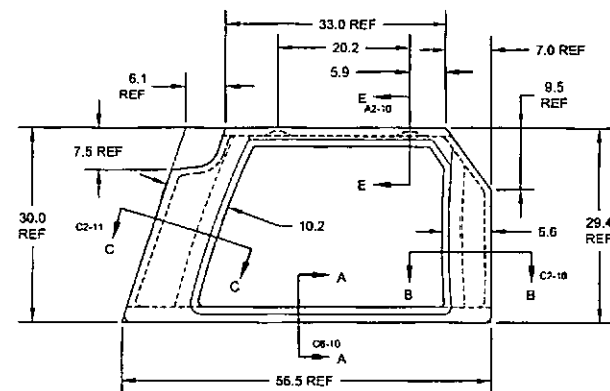
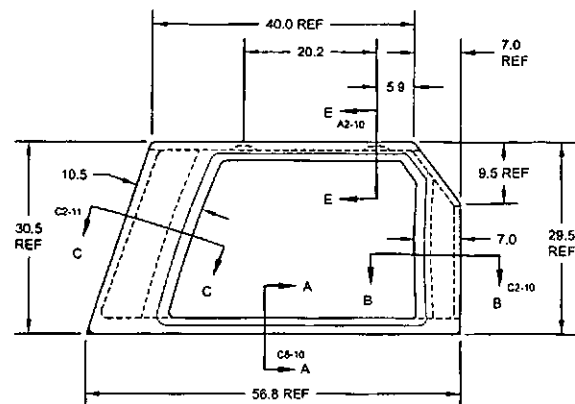
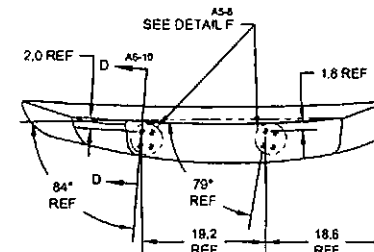
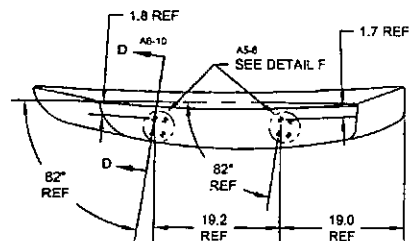






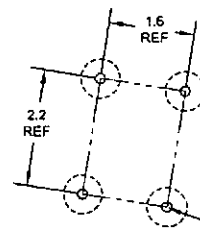






**D3188-1M SPACEPOD BODY**

**D3188-3M SPACEPOD BODY**



**DETAIL F**

INSTALL  
D2213 SPACER  
8 PL  
SEE SECTION D-D  
A5-10

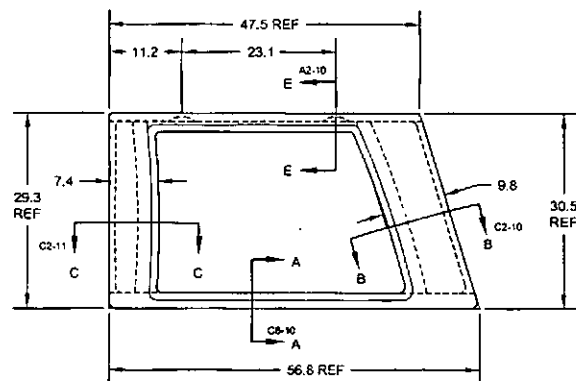
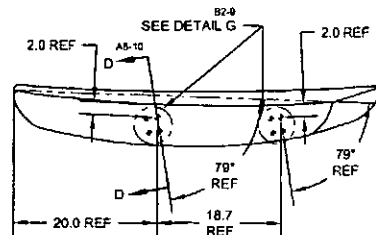
**D3188-1M/-3M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

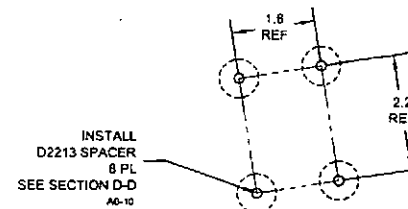
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**D3188-2M SPACEPOD BODY**







**DETAIL G** D6-8

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2009-10-20

**D3188-2M NOTES:**

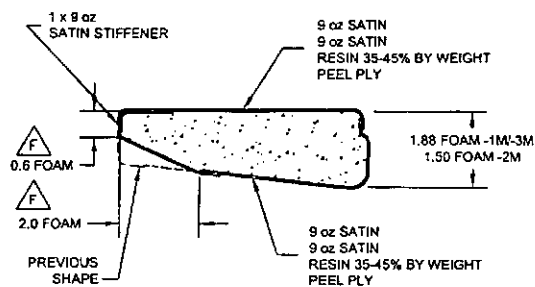
- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

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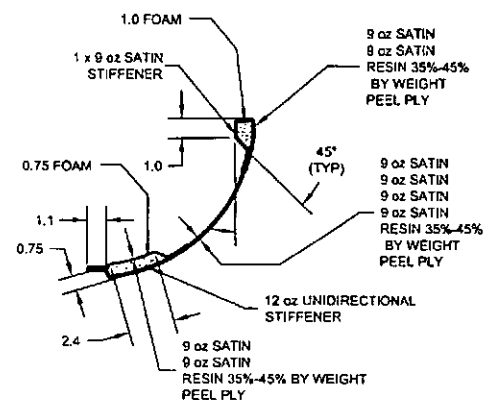




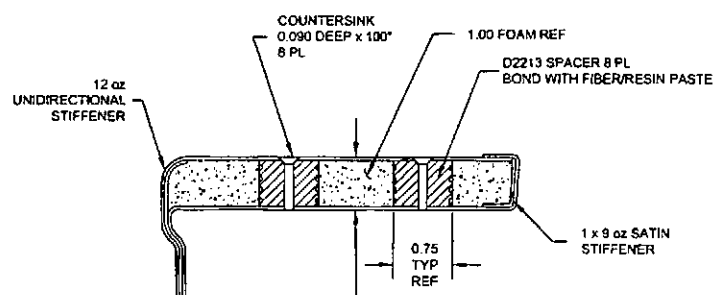
OUTBOARD



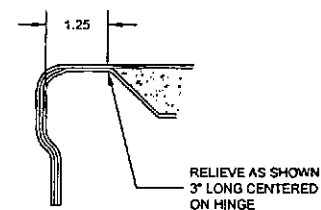
**SECTION A-A**  
TYPICAL FLOOR SECTION  
B7-8  
B3-8  
B5-8



**SECTION B-B**  
SECTION C-C OPPOSITE  
B6-8  
B8-8  
B4-8  
B2-8  
B7-8  
B5-8



**SECTION D-D**  
TYPICAL ROOF SECTION IS SIMILAR  
BUT WITHOUT INSERTS  
D3-8  
D7-8  
D6-8

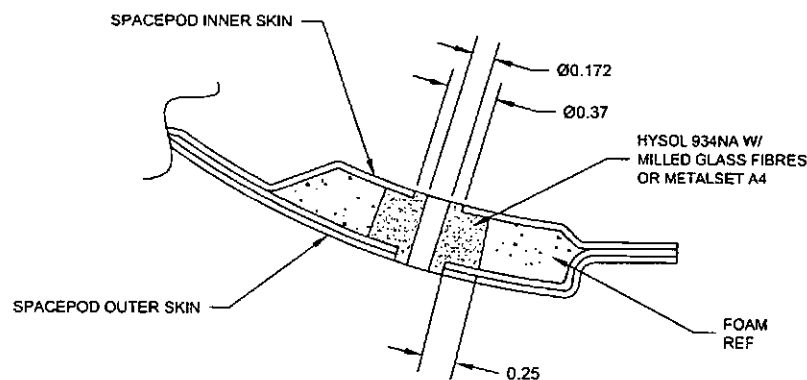
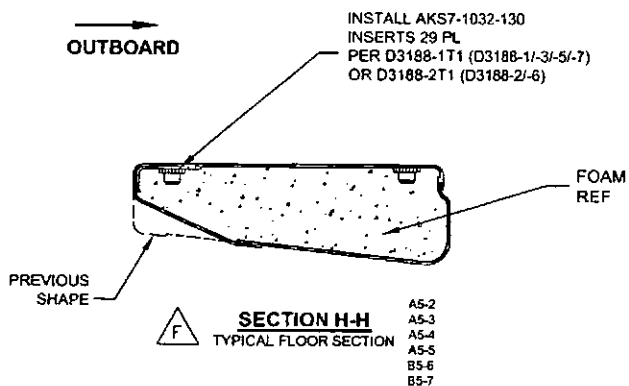


**SECTION E-E**  
2 PLACES PER POD  
C7-8  
C7-8  
B5-8

**RELEASED**  
2009-10-20

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
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**SECTION I-I**  
**SECTION J-J OPPOSITE**  
4 PLACES PER POD

CS-5  
C4-6  
CS-7

**RELEASED**  
2009-10-20

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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 11 OF 11
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO18720

Purchase Order Date 1/04/13

PO Print Date 1/15/13

Page Number 2 of 2

Order From :

DELASTER INC  
2699 5E AVENUE, LOCAL C.P 10100

U-DEL003

GRAND-MERE, QC G9T 5K7  
CA

Contact Name

Vendor Phone

819 533 5788

Vendor Fax

819 533 3494

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Special In

AS PER DWG D3188 REV. F  
B95145

5

D3186-2F

Spacepod Door

1/31/13

Yes

1.00

Each

FedEx Overmigh

\$750.0000

\$750.00

Special Inst:

AS PER DWG D3186 REV. E  
B95612

6

D3188-2F

Spacepod Body

1/31/13

Yes

1.00

Each

FedEx Overmigh

\$2,177.0000

\$2,177.00

Special Inst:

AS PER DWG D3188 REV. F  
B95611

PO Total:

\$8,781.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

Change Nbr:

3

Change Date: 1/15/13

No substitution or deviation without  
consent.

Certificate of Conformity or Material  
Certification required - YES NO



Mastering Innovation



DELASTEK Inc.  
2699 Se Avenue  
Local 14, C.P. 10100  
Grand-Mère, Québec G9T 5K7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	47947
Customer No.	DART US

## Bill To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

## Ship To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle



Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
06-05-2013	22-01-2013	22731	Brigitte Golden	18720	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX PI Collect		Point de départ		Mathieu Doucet, ext.690	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0071	Line 6 N° D3188-2M, Spacepod Body RH B95611 U of M: Chaque Dwg. D3188 Rév.: F	
				Serial #	Lot #
				48901	48901

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request*

Accepted by:

Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

1

"

1

6



Date: Mercredi, 2013-01-30 10:29:08  
Utilisateur: Mario Chénail

## Feuille de Procédé

4 / 28 Jan

Client	: DART US DART AEROSPACE	Nom Dessin	: SPACEPOD BODY RH
Numéro Job	: 48901	Numéro Article	: DKC134-0071
Numéro	: 3763	Numéro Dessin	-
Numéro B.A.	:	Projet Numéro	: OK-362
Cette fois	: 2013-01-30 No. :	Révision dessin	:
Prsht Rev.	: NC	Matériel	: Fibre 7781 et résine 411-350
Prem. fois	: - - Type :	Date Dûe	: 2013-02-25 Qté: 1 Ud UNITE
Job précédente	: 45779		

Écrit par : MC 4720  
Vérifié & Approuvé par : \_\_\_\_\_  
Commentaires : N° de dessin: D3188-2M rev. F

E.O.: N/A

Feuille de Procédé Rév.: 06 AMB0349 remplacé par  
AMB0511 (réf. RFC #226)

Formulaire d'inspection: N/A

### Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
Comment	Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)	
	N° 83634, Frekote Loctite Wolo	N° de Lot: <u>1-374</u>

2.0	PRÉPARATION	Préparation du moule
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Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule selon IF134-0020.

Date: 15/2/13 Scéau: 

3.0	AAC1885	Tissu à délaminer Release ply B
Comment	Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)	
	Tissu à délaminer Release ply B	# de Lot: <u>N/A</u>

4.0	AAC1887	Wrightlon 5200 Bleu P3
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Comment	Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)	
	Wrightlon 5200 Bleu P3	# de Lot: <u>N/A</u>

5.0	AC0885	Feutre de drainage N° Airweave N 10
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Comment	Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)	
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### Feuille de Procédé

Cliant: DART US DART AEROSPACE  
Numéro Job: 48901  
Nom Dessin: SPACEPOD BODY RH  
Numéro: DKL134-0071



# Séq.: Machine ou Opération: Description:

6.0 AC0943 Stretchlon 200 poche à vide Veri  
Comment Qty.: 7.00 VERGE(s)/Unit Total: 7.00 VERGE(s)

7.0 AMB0214 9.7 oz Weave "S" glass #FG-77815-125Y Volan Finish  
Comment Qty.: 11.4 VERGE(s)/Unit Total: 11.4 VERGE(s)  
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-39576-1

8.0 AMB0511 N° TG-13-U, Fiberglass 13 oz  
Comment Qty.: 0.80 VERGE(s)/Unit Total: 0.80 VERGE(s)  
N° TG-13-U, Fiberglass 13 oz N° de Lot: 1-36302-1

9.0 AMB0213 WR1850 Roving 18oz. x 50"  
Comment Qty.: 0.350 KILOGRAMME(s)/Unit Total: 0.350 KILOGRAMME(s)  
WR1850 Roving 18oz. x 50" N° de Lot: 1-35539-1

10.0 AC0886 Ruban à gommer jaune #: T/AT 200  
Comment Qty.: 4.0000 ROULEAU(s)/Unit Total: 4.0000 ROULEAU(s)

11.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs

Tailler les tissus selon IF134-0020

Date: 14/02/13 Scellé: 32

12.0 AMB0286 Catalyst N° DDM-9  
Comment Qty.: 0.0640 GALLON(s)/Unit Total: 0.0640 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

13.0 AMB0212 Résine (411B7530) 411-350 promo. 75 min  
Comment Qty.: 2.000 LITRE(s)/Unit Total: 2.000 LITRE(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-39253-1

14.0 AAC1540 Fibre de verre Miapoxy 66  
Comment Qty.: 0.0040 GALLON(s)/Unit Total: 0.0040 GALLON(s)  
Fibre de verre Miapoxy 66 N° de Lot: 1-37956-1

15.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs













Laminer la 1ère coquille selon IF134-0020.

Date: 15/02/13 Scellé: 7 65 30

1990

Date: Mercredi, 2013-01-30 10:29:08  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: SPACEPOD BODY RH	
Numéro Job: 48901		Numéro: 0134-0071	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description:	
16.0	AMB0355	ATC core-cell A500 plain 4'x8' 1" thick	
Comment	Qty.: 0.750 FEUILLE(s)/Unit Total: 0.750 FEUILLE(s) ATC core-cell A500 plain 4'x8' 1" thick N° de Lot: 1-38256-1		
17.0	TAILLAGE	Faire le taillage du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 120.0000Min Total Run: 2.0000Hrs  Tailler et ajuster les Foam Core selon IF134-0020.  Date: 08/03/13 Sceau: 		
18.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.136 KILOGRAMME(s)/Unit Total: 0.136 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-39238-1		
19.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0096 GALLON(s)/Unit Total: 0.0096 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27829-1		
20.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs  Sceller les foam core selon IF134-0020.  Date: 08/03/13 Sceau: 		
21.0	PERCAGE	Perçage de trous	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  Perçer les foam core selon IF134-0020.  Date: 11/03/13 Sceau: 		
22.0	AAC1611	Polybond B46F	
Comment	Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s) Polybond B46F N° de Lot: 1-29934-1		
23.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs  Installer les foam core selon IF134-0020.		

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Utilisateur: Mario Chantal

Mardi, 2013-01-30 10:29:08

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 48901

Nom Dessin: SP-CEPOD BODY RH  
Numéro: DKG134-0071

Numéro Job:



# Séq.:

Machine ou Opération:

Description:

Date: 11/08/13 Sceau:



24.0 AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.050 GALLON(s)/Unit Total: 0.050 GALLON(s)  
N° P-15-3, Adtech Micro Ultra Filler # de Lot: L-40322-1

25.0 FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

Usiner les foam core selon IF134-0020.

Date: 20-03 Sceau: 4435



26.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 1.600 KILOGRAMME(s)/Unit Total: 1.600 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-39222-1

27.0 AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0536 GALLON(s)/Unit Total: 0.0536 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

28.0 LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs

Laminer les plis de 9oz selon IF134-0020.

Date: 20-03 Sceau: 4435



29.0 TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs

Faire le taillage selon IF134-0020.

Date: 20-04 Sceau: 4435



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30.0 AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0144 GALLON(s)/Unit Total: 0.0144 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

31.0 AAC1540

Fibre de verre Miapoxy 66




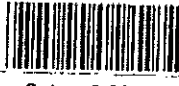





Comment Qty.: 0.0420 GALLON(s)/Unit Total: 0.0420 GALLON(s)  
Fibre de verre Miapoxy 66 N° de Lot: 1-37956-1





Date: Mercredi, 2013-01-30 10:29:08  
Utilisateur: Mario Chantal




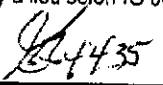






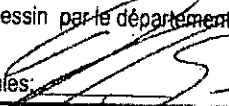


## Feuille de Procédé

Client:	DART US DART AEROSPACE		Nom Dessin:	SPACEPOD BODY RH
Numéro Job:	48901		Numéro	DKC134-0071
Numéro Job:				
# Séq.:	Machine ou Opération:	Description:		
32.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.		
Comment	Qty.: 0.450 KILOGRAMME(s)/Unit Total: 0.450 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-3518-1 4435			
33.0	LAMINAGE	Faire le laminage		
				
Comment	Setup: 0.00Hrs/ Run: 55.0000Min Total Run: 0.9167Hrs Faire le laminage des derniers plis 9oz selon IF134-0020. Date: 12-04-83 Sceau: 4435			
34.0	AAC1610	Spacer N° D2213		
Comment	Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) Spacer N° D2213 N° de Lot: 1-39471-1			
35.0	ASSEMBLAGE	Assemblage mécanique		
				
Comment	Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs Faire l'assemblage des inserts selon IG 0097 Date: 16-04 Sceau: 4435			
36.0	AAC1021	Dupont Primer N° 7704S		
Comment	Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-37302-1			
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase		
Comment	Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-37302-3			
38.0	FINITION	Finition Générale		
				
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Préparer la pièce selon IG 0008. Date: 17-04 Sceau: 4435			
39.0	PRIMER	Application primer		
				
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Préparer et appliquer le primer selon IG 0008. Date: 19-04 Sceau: 4435 # de fiche de mélange: N/A			



Date: Mercredi, 2013-01-30 10:29:08  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: SPACEPOD BODY RH	
Numéro Job: 48901		Numéro: 140134-0071	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description:	
40.0	AAC1492	N° P-15-3, Adtech Micro Ultra	
Comment	Qty.: 0.010 GALLON(s)/Unit Total: 0.010 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-40372-1		
41.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs Faire les réparations de finition s'il y a lieu selon IG 0008. Date: 23-04-13 Sceau: 		
42.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-37302-		
43.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-37302-		
44.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Préparer et appliquer le primer selon IG 0008. Date: 24-4-13 Sceau:  # de fiche de mélange: 21/4		
45.0	INSPEC FINAL	Inspection finale	
			
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs Faire l'inspection générale de la pièce selon le dessin par le département de la qualité. Date: 3-5-13 Sceau:  Initiales: 		
46.0	EMBAL / ENTREPO	Emballage & Entreposage	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire l'emballage selon IG 0057. Date: 3 Mai 2013 Sceau: 